

# CONTROL METHOD FOR END-SEALING TIME IN BAG-MAKING-FILLING-PACKAGING MACHINE

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 Inventor: TAKIGAWA SADAOMI  
 Applicant: KAWASHIMA PACKAGING MACH  
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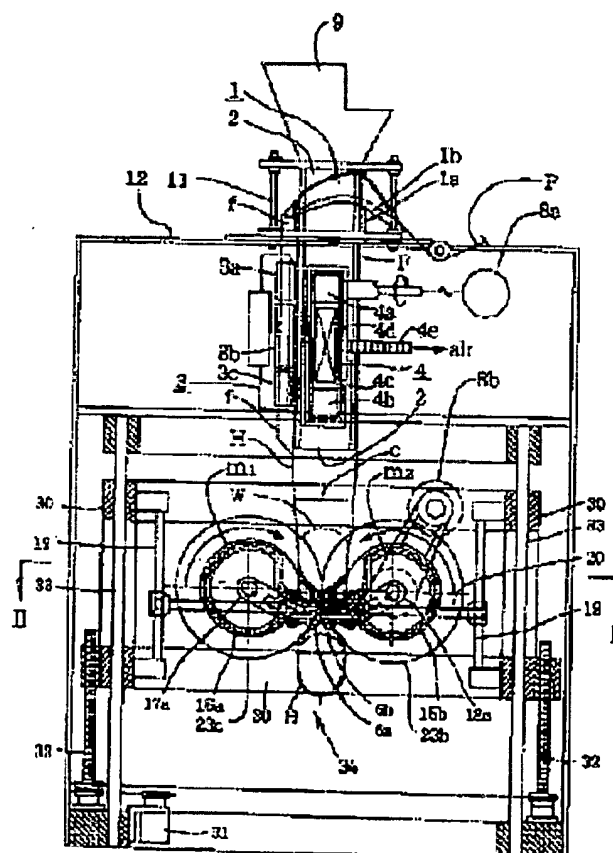
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## Abstract of JP10297619

**PROBLEM TO BE SOLVED:** To provide a firm sealing by a method wherein when a lateral sealing is performed after longitudinally sealing film both edges of a packaging film, a box motion is formed by a servo motor, and a sealing time in one cycle of a specified period of time based on a sealing distance, is controlled in a manner to become relatively longer. **SOLUTION:** A packaging film F is folded in a manner to wrap a product filling cylinder 2, and the film both edges are longitudinally sealed by a longitudinal sealing device 3, and a packaging cylinder H is obtained, and then, the packaging cylinder H is pulled down by a feeding device 4, and the filling of a content, and a lateral sealing and a cutting are performed. At the time of this packaging work, to a lateral sealer-cutter 5, a box motion is imparted by following a pair of cam curves m1, m2 with a servo motor 8b as the power source, and in this case, a returning time from a lateral sealing completion position to a lateral sealing starting position is quickened, and in the meantime, the lowering speeds of the packaging cylinder H and the lateral sealer-cutter 5 in the lateral sealing section are made slower, and thus, the sealing time is made relatively longer, and the sealing strength is increased.



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